RG 104, 8NS-104-94-077
Box 6

8NS-104-94-077, Miscellaneous
Correspondence & Memos, 1897-1994

Notes on Liberian Currency

Liberian 10¢

4-24-75

Sample

5 Blanks

TM-75-1050-1

Liberian - Proof

old

10-Cent.

.0365

28 grains

Liberian - Proof

$1

.088+

277 grains

10-Cent.

Liberia NEW

Uncirculated

dia = .668

Wt = 31.945 gr.

thickness = .0415

std = 041+

NEW. 5-25-70

Liberian Proof

50-Cents

.061+ Thickness

1.135 Diameter

139 grains

4-23-75

Liberian 5¢

Sample

5 Blanks

4-23-75

Liberian #100

Sample

5 Blanks

Liberian - Proof

5-Cents

.058

64 grains

#5

Liberia

4-28-75

Liberian 50¢

TM-75-1050-1

Sample

5 Blanks

4-22-75

Liberian 25¢

Sample

10 Blanks

#1 - Liberia

Mint

.1015 = std

1.338 - Liberia

320.22 grs. = w

.102 Thick

Rev. 5-21-70

24,000 grain
per ingot.
Liberian - Proof

25-Cents.
.0485
.0495 - ~~.061~~

70 grains

Liberian 1¢

4-24-75

Sample

5 Blanks

Tm-75-1051-1¢

Liberia ~~*~~ 5-

1.654.

550 grains

35.64 grams

Panama - 5- Balboa

1.344 dia -

1.37 [illegible] wt

OPTIONAL FORM NO. 10
MAY 1962 EDITION
GSA FPMR (41 CFR) 101-11.6

UNITED STATES GOVERNMENT

Memorandum

Blanking

TO : Coining, Mechanical, Assay Divisions **DATE:** March 27, 1975

FROM : Accounting

SUBJECT: Supplement to Labor Distribution Job Number Listing, No. LDD-75-3.
Re: D/M Letter dated 1/15/75, Liberia Order (13,800,000 Pieces)

Job Numbers to be used for Liberia functions on 1¢, 5¢, 10¢, 25¢, 50¢, and $1.00 coins are as follows:

1. Coining

	Job Number
a. Process Weigh	
1. 1 Cent	118-056
2. 5 Cent	118-057
3. 10 Cent	118-058
4. 25 Cent	118-059
5. 50 Cent	118-060
6. 1 Dollar	118-061
b. Blanking	
1. 1 Cent	120-056
2. 5 Cent	120-057
3. 10 Cent	120-058
4. 25 Cent	120-059
5. 50 Cent	120-060
6. $1.00	120-061
c. Materials Handling	
1. 1 Cent	127-056
2. 5 Cent	127-057
3. 10 Cent	127-058
4. 25 Cent	127-059
5. 50 Cent	127-060
6. $1.00	127-061

2. Mechanical

a. Making and/or sharpening punches	
1. 1 Cent	601-756
2. 5 Cent	601-757
3. 10 Cent	601-758
4. 25 Cent	601-759
5. 50 Cent	601-760
6. $1.00	601-761

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

Subject: Supplement to Labor Distribution Job Number Listing, No. LDD-75-3.
Re: D/M Letter dated 1/15/75, Liberia Order (13,800,000 Pieces)

	Job Number
3. Assay	
a. Assaying Functions	
1. 1 Cent	181/183-485
2. 5 Cent	181/183-486
3. 10 Cent	181/183-487
4. 25 Cent	181/183-488
5. 50 Cent	181/183-489
6. $1.00	181/183-490

DISTRIBUTION: Coining Office ✓
Mechanical Office
Assay Office
Cost Accounting File
DIPS Coordinator
Sup't. Secretary

12/22/74
WHD

LIBERIAN SPECS

	1¢	5¢	10¢	25¢	50¢	$1.00
THICK BLANK	.047"	.058"	.0365"	.049"	.060"	.088"
DIA. (CUT) BLANK	.704 .704-.705	.793 .793	.668 .668	.905	1.135	1.338 1.338
DIA. UPSET BLANK	.695	.778	.652; 653	.892 (S.F.)	1.125 (S.F.)	1.316 ± 1
THICK UPSET BLANK	.057	.070	.052	.060 (S.F.)	.073 (S.F.)	.118
DIA. COIN	17.9 MM 0.7047	20.0 MM 0.7874	17.0 MM .6693	23.0 MM .9055	29.0 MM 1.1417	34.0 MM 1.3386
THICK COIN	.057	.070	.0518			.118
WEIGHT Cook-acct.	2.59 g.	4.15 g	31.945 gr.			320.22 ± 6 gr.
~~HARDNESS~~ 120 —	056	057	058	059	060	061

RED FIGURES FROM MACHINE SHOP DIE INVENTORY SHEET

Blank thickness for 10¢ & $1.00 was thicker in 1970, but coin specs (weight) was changed at future determinations after 1970.

12/27/74

THEORETICAL RECOVERY

DENOMIN.	LIBERIAN DIE DIA. REQD.	NUMBER OF BLANKS/STROKE	STEP	YIELD
	U.S. BLANKS			
1	0.704 IN. .741	16	0.622 IN.	62.8 %
5	0.793 IN. .530	14	0.676 IN.	64.1 %
10	0.668 IN. .695	17	0.574 IN.	65.1 %
25	0.905 IN. .956	13	0.778 IN.	67.4 %
50	1.135 IN. 1.104	10	0.947 IN.	67.1 %
1.00	1.338 IN. 1.494	8	1.199 IN.	58.9 %

ABOVE FOR 12 INCH STRIP (11.9375 IN.)

Liberian Coin Programs

1970 - MAY — Letter from Tate to Rigby 5/7/70

				Non Proof
.102"	1¢ (coin)	34 mm	20.75 grams.	2,000,000 Coins
.345"	10¢ (coin)	17 mm	2.67 grams	2,000,000 Coins

1971 - Feb 11 — Letter Tate to Rigby (20,000 Proof coin blanks)

	5¢	340 mm	17.91 grams.
		17 mm	1.314 g

1973 - April 2 — Ambrose Mann Fiscarelli (Proof Coin)

We made 20,000 coin blanks. All denominations inch mm 5¢

1¢	34 mm	17.91 grams.
10¢	17.0 mm	1.79 grams.

Aug 9, 1973 — We made 20,000 blanks all denominations

1¢	.088	thickness gauge
10¢	.1365	

Coin specs. (weight) has been changed since 1970 for 10¢ + $/00 to above figures.

		Diameter	Wt (grams)
10¢	.345"	17mm	2.67
1¢	.102"	34 mm	20.75

Proof Coin, Ask you on 2.

10¢ .0345" 17 mm 1.79

1¢ .102" 34 mm 17.91

Actual Coin weight has been changed since 1972.

LIBERIAN COINAGE INFORMATION

4-28-75

Denomination	1¢	5¢	10¢	25¢	50¢	$1.00
Net.lbs.Rec.	55,872	33,721	31,325	28,595	28,342	32,007
Manufacturer	Ana.	Revere	Revere	Revere	Revere	Revere
% of Recovery	~~62%~~ 67%	62%	65%	68%	68%	69%
Diameter	.704-.705	.793	.668	.905	1.135	1.338
Thickness	.047	.058	.0365	.049	.060	.088
Type of Mat.	Cu Zn 95 5	Cu Ni 75 25	Cu Ni 75 25	Cu Ni 75 25	Cu Ni 75 25	Cu Ni 75 25
Good Blanks Shipped-lb.	37,152	20,921	20,487	19,512	19,132	22,328
Date Blanked	4-25-75	4-22-75	4-24-75	4-23-75	4-28-75	4-21-75
# Drums to S.F.	28	18	20	18	16	20

* Tolerance ± 0.002

ORDER ESTIMATE

	% Yield	No. of Blanks	Lbs. of Blanks
1¢	57%	5,350,000	31,800
5¢	59%	2,140,000	20,400
10¢	60%	4,290,000	17,600
25¢	62%	1,710,000	17,600
50¢	62%	860,000	17,600
$1	53%	430,000	17,600

F-

LIBERIA
1977

DEPARTMENT OF THE TREASURY
WASHINGTON, D.C. 20220

OFFICE OF
DIRECTOR OF THE MINT

RECEIVED
MAR 5 1975
U.S. MINT AT DENVER

March 3, 1975

Mrs. Betty Higby
Superintendent
United States Mint
320 W. Colfax Street
Denver, Colorado 80204

Dear Mrs. Higby:

We awarded Contract TM 75-1015, of February 27, to Anaconda American Brass for 55,800 pounds of bronze strip for Liberia one cent coin production. This material will be shipped to you within 30 days from AAB Bufialo Plant and will be blanked by your facility and the cut blanks forwarded to the SFAO for processing into coins. Blanking scrap is to be returned to AAB in containers to be furnished with the strip.

The following factors and similarity in specifications require your exercising care in identifying and segregating the Liberia one cent strip from your U.S. one-cent strip material, both prior to and during processing. This action is necessary to preclude mixing same with U.S. one-cent material.

1. Although required by Contract, AAB may fail to identify the material by strip gage.

2. Similarity in strip specifications:

	Liberia One-Cent	U.S. One Cent
Gage	.0470 ± .0015"	.0495 ± .0015"
Strip Width	11 15/16"	11 15/16"
Alloy	95 Cu/5 Zn	95 Cu/5 Zn
Coil Wt.	2,000 lbs.	2,000 lbs.
Packaging	---------- same ----------	

3. AAB has an ongoing annual contract for concurrent delivery of U.S. one-cent strip to the Denver Mint, although Olin is currently making delivery of this material for AAB.

orig & Harvey Lee
copy Quality Control
Cash Div.
Acct Div.

Keep Freedom in Your Future With U.S. Savings Bonds

Upon your shipment of the resultant approximately 40,000 pounds of Liberia one-cent cut blanks to the SFAO, please clearly identify such material due to gage and diameter being close to the U.S. one cent blank.

Contract TM 75-1050 for a total of 154,100 pounds of cupro-nickel strip (75/25) for the five denominations (5-cent through 1 dollar) Liberia coins was awarded to Revere Copper and Brass, Inc., on February 24. Care must be exercised in the proper identification and segregation of this material as well, due to similarity to U.S. coinage materials.

Sincerely,

George G. Ambrose
Assistant Director for Production

OPTIONAL FORM NO. 10
MAY 1962 EDITION
GSA FPMR (41 CFR) 101-11.6

UNITED STATES GOVERNMENT

Memorandum

R&C

LIBERIA
1977

TO : Coining, Cash, Mr. Frost

DATE: March 3, 1975

FROM : Harry E. Lawrence
Deputy Superintendent

SUBJECT: Liberia Coinage Strip

Within the next 30 days, Anaconda will be shipping us 95-5 Bronze Strip for Liberia one-cent pieces.

The gauge of this strip is .0470 ± .0015. Please make certain that this material does not get mixed with U. S. one-cent strip.

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

NEW ONE DOLLAR - LIBERIAN 5-21-70

Rec @ .215 Nix-Alloy

PASS	DIAL.	GAUGE	X-RAY	
1-	235	.190		
		ANNEAL.		
2-	195	.155		
3-	175	.130		
4-	165	.110.	SELECT.	175
5-	160	.102		157

± 6 grs.

EDGE = .099 - .1005 - STD = .1015 DIA - 1.338 WT = 320.22 GRAINS.

.100 = - 5 grs. - 103 = + 5 grs CENTER STRIP = .102

6" Strip

NEW 10 CENTS - LIBERIA. 5-26-70

Rec, @ .215 Nix-Alloy

PASS	DIAL	GAUGE	X-RAY	
1-	235	.190		
		ANNEAL.		
2-	190	.152		
3-	155	.118		
4-	135	.090		
5-	120	.072		
6-	110	.059		
7-	104	.048	SELECT	076
8-	96	.0415		063 + 1/4

± - 1.5 grs.

EDGE = .039 - .040 - STD = .041 DIA = .668 WT = 31.945

LIBERIA #1 PROOF

9-19-73

NIX ALLOY

PASS	DIAL	GAUGE		X-RAY
1	.225	.190		
	ANNEAL			
2	195	.150		
3	170	.125		
4	160	.110		
5	150	.091	select	155
6	145	.088		134

edge .086 dia 1.338 wt 277 gr.

Empire nickel

4-9-72

Rec @ .215

5 Cents Liberia

Pass	Dial	Gauge		X ray
1	225	.190		
	anneal			
2	185	.147		
3	150	.115		
4	130	.090		
5	125	.072	select	115
6	110	.058		092 #1

Edge .055½ Wt 64 grains Dia .793

LIBERTY - 50¢

9-19-73

Nix Alloy

PASS	DIAL	GAUGE	X-RAY
1	225	.190	
	ANNEAL		
2	185	.147	
3	150	.115	
4	130	.090	
5	130	072	Select 115
6	110	.061	094+

edge .059 dia 1.135 wt. 139 grs

LIBERTY 25¢

Nix-Alloy

9-19-73

PASS	DIAL	GAUGE	X-RAY
1	225	.190	
	ANNEAL		
2-	185	.147	
3-	150	.114	
4-	130	.090	
5-	120	.072	
6-	110	.062	Select 093
7-	105	.049	075

edge .0475 dia .905 WL 70 grs

Form 8903
Treasury Department
U.S. Mint Service

FOREIGN COINAGE

ADMINISTRATIVELY CONFIDENTIAL

Government Liberia

No. Pieces 3,000,000

Date order received February 22, 1972
Mint where coined Denver
Denomination Five Cent
Date coinage started April 3, 1972
Date coinage completed April 24, 1972
Cost per M
Alloy 75 Cu - 25 Ni
Weight per coin 4.15 Grams
Weight tolerance
Fineness Tol.
Diameter 20.0 MM .7874 Tol.
Thickness .070 Tol.
Reeded edge
Plain edge Yes
Lettered edge No
Wastage allowed per M
Turn - standard or medal Standard
Year (dated) 1972
Mint mark
Was sample coin submitted Yes
Was sample strike approved

Was master die furnished No
Was master die returned
Number melts made 137 Ingots
No, melts delivered to Coiner 137
Ounces per melt
No. ingots per melt
Weight per ingot 400 lbs - 6,000 oz
Size of ingot 60"x12 1/8"x1 3/4"
Assay passing tol. on ingot
Diameter of cut blank .793
Thickness of cut blank .058
Diameter of upset blank .778
Edge thickness upset blank .070
Pieces cut across strip 7
Pieces cut at one stroke 14
Annealing temperature 1400°
% rejects, automatic scales
% rejects if reviewed
% good coins from ingots 54%
No. pieces per bag 4,000
Weight tol., M pieces

Date shipped

Remarks: Used nickel U.S. equipment for stamping. Used nickel upsetting. Used conventional presses. Poor recovery becasue a quarter die set was used - more waste.

DIE AVERAGE:
Obverse - 158,000
Reverse - 167,000

1-20-75

Haiti:

10 Centime - .903 12" Strip
25¢ Liberian Die

20 Centime - 1.031 6" Strip
Die Ready

50 Centime - 1.142 12" Strip

Liberia:

1 Cent - .704	12" Strip
5 Cent. - .793	12" Strip
10 Cent - .668	12" Strip
	Die Ready
25 Cent - .905	12" Strip
50 Cent - 1.135	6" Strip
	Die Ready
1 Dollar - 1.338	6" Strip
	Die Ready

R+C

DEPARTMENT OF THE TREASURY
WASHINGTON, D.C. 20220

OFFICE OF
DIRECTOR OF THE MINT

RECEIVED
JAN 17 1975
OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

JAN 15 1975

Superintendent, United States Mint, Philadelphia, Pennsylvania
Superintendent, United States Mint, Denver, Colorado
Officer in Charge, United States Assay Office, San Francisco, Calif.

The Government of Liberia has approved our cost estimate for the manufacture of 13.8 million 1975-dated circulating coins, the specifications for which are as follows:

Denom	Quantity	Alloy	Wt. (Grams)	Dia. (MM)	Thickness (MM)
1¢	5,000,000	95 Cu - 5 Zn	2.59	17.91	1.40
5¢	2,000,000	75 Cu - 25 Ni	4.15	19.99	1.73
10¢	4,000,000	"	1.79	16.99	1.17
25¢	1,600,000	"	4.49	23.00	1.50
50¢	800,000	"	8.97	29.00	1.91
$1	400,000	"	17.94	34.00	2.74
	13,800,000				

1¢ and 5¢ plain edge; 10¢ through $1 reeded edge.

Tolerances: Diameter: ± 0.076 MM
Edge Thickness: ± 0.127 MM - 0.076 MM
Weight: ± 4.0%

The SFAO and Denver Mint will be involved in the production of these coins to the extent outlined. Philadelphia will be responsible for trial striking each denomination and furnishing working dies, reeded collars, and coin bags.

PHILADELPHIA MINT

1. Trial strike each denomination.
Specifications:

	1¢	5¢	10¢	25¢	50¢	$1
CUT BLANK						
Diameter	0.704"	0.793"	0.668"	0.905"	1.135"	1.338"
Thickness	0.047"	0.058"	0.035"	0.049"	~~0.061"~~ 0.060"	0.087"
UPSET BLANK						
Diameter	0.699"	0.783"	0.660"	0.892"	1.125"	1.325"
Thickness	0.054"	0.069"	0.046"	0.060"	0.073"	0.098"

Keep Freedom in Your Future With U.S. Savings Bonds

Tolerances:

Cut Blank
Diameter: All ± 0.003
Thickness: 1¢ through 50¢ ± 0.0015; $1 ± 0.0020

Upset Blank
Diameter: All ± 0.001
Thickness: All ± 0.001

Please prepare an ample supply of blanks for trial striking. It is understood that you have collars for each denomination.

2. Upon receipt of orders from the SFAO, manufacture and ship dies, reeded collars, and coin bags.

DENVER MINT

1. Receive and blank the following coinage strip using existing blanking die sets.

	Alloy	Quantity	Gauge (±.0015)	Strip Width (± 1/32)
1¢	95 Cu - 5 Zn	55,800 lbs.	0.047"	11 15/16"
5¢	75 Cu - 25 Ni	34,600 lbs.	0.058"	11 15/16"
10¢	"	29,300 lbs.	0.035"	11 15/16"
25¢	"	28,500 lbs.	0.049"	11 15/16"
50¢	"	28,400 lbs.	~~0.060"~~ 0.061"	11 15/16"
$1	"	33,300 lbs.	0.087" *	11 15/16"
		209,900 lbs.		

2. Expected yield from this material, based on information provided by Mr. Darlington to Mr. Collicelli, is as follows:

	% Yield	No. of Blanks	Lbs. of Blanks	Material
1¢	57%	5,350,000	31,800	55,700 lbs
5¢	59%	2,140,000	20,400	34,500 lbs
10¢	60%	4,290,000	17,600	29,000 lbs
25¢	62%	1,710,000	17,600	28,500 lbs
50¢	62%	860,000	17,600	28,500 lbs
$1	53%	430,000	17,600	33,200 lbs

*tolerance ±0.002

Please note that standard weight plus 4.0% was used to compute strip requirements and the number and weight of blanks yielded therefrom. We believe that this is necessary to assure the adequacy of material in the event of "heavy blanks." This practice will continue in all future foreign coinage orders unless otherwise stated.

3. Ship cut blanks to the SFAO and return blanking scrap to the strip fabricator in containers to be provided by him.

SFAO

1. Receive the cut blanks from Denver and process into coins.

2. Place orders for working dies and reeded collars.

3. Fabricate in-house or arrange for purchase of collars for the one and five cent denominations.

4. Place order for coin bags, and initiate procurement action on boxes and skids. Markings for bags and boxes are yet to be provided by Liberia.

5. Package coins for shipment in the following manner:

	Coins Per Bag	Bags Per Box	Boxes Per Skid	Total Bags	Total Boxes	Total Skids
1¢	5,000	2	36	1,000	500	14
5¢	4,000	2	30	500	250	9
10¢	10,000	2	28	400	200	15
25¢	4,000	2	28	400	200	5
50¢	2,000	2	28	400	200	5
$1	1,000	2	28	400	200	5
				3,100	1,550	

Production of this order is to commence as soon as practical after completion of the 33.2 million piece Haiti order; based on present estimates, we can expect the start-up date to be the week of April 7, 1975 with completion the week of May 5, 1975.

The cost of manufacture for this order includes delivery, C.I.F., Monrovia, Liberia.

Sincerely,

Mary Brooks
Director of the Mint

R & C

DEPARTMENT OF THE TREASURY
WASHINGTON, D.C. 20220

OFFICE OF
DIRECTOR OF THE MINT

January 17, 1975

RECEIVED
JAN 20 1975
OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Mrs. Betty Higby
Superintendent
United States Mint
Colfax and Delaware Streets
Denver, Colorado 80204

Dear Mrs. Higby:

In the letter of January 15, 1975 from the Director of the Mint to you regarding Liberian coinage, there is one minor misprint on page 2. The proper thickness for 50¢ coinage strip should read 0.061" rather than 0.060". Coinage strip for the 50¢ piece is being purchased with a thickness specification of 0.061" ± 0.0015" and the quality control and coining divisions should be made aware of this correction.

Thank you.

Sincerely,

Alan J. Goldman
Assistant Director for Technology

Correct your copy of the Jan. 15th letter to show this change!
LWHD

orig: Coining Div.
copy: Acct. Div.
Cash Div.
Bldg. + Mech. Div.
Assay Div

Keep Freedom in Your Future With U.S. Savings Bonds

12/22/74
WHD

LIBERIAN SPECS

	1¢	5¢	10¢	25¢	50¢	$1.00
THICK BLANK	.047"	.058"	.0365"	.049"	.060"	.088"
DIA. (CUT) BLANK	.704 .704-.705	.793 .793	.668 .668	.905	1.135	1.338 1.338
DIA. UPSET BLANK	.695	.778	.652;653	.892 (S.F.)	1.125 (S.F.)	1.316 ± 1
THICK UPSET BLANK	.057	.070	.052	.060 (S.F.)	.073 (S.F.)	.118
DIA. COIN	17.9 MM 0.7047	20.0 MM 0.7874	17.0 MM .6693	23.0 MM .9055	29.0 MM 1.1417	34.0 MM 1.3386
THICK COIN	.057	.070	.0518			.118
WEIGHT	2.59g.	4.15g	31.945 gr.			320.22 ± 6 gr.
HARDNESS						

RED FIGURES FROM MACHINE SHOP DIE INVENTORY SHEET

Blank thickness for 10¢ + $1.00 was thicker in 1970, but coin specs (weight) was changed on these denominations after 1970.

12/27/74

THEORETICAL RECOVERY

DENOMIN.	LIBERIAN DIE DIA. REQD.	NUMBER OF BLANKS/STROKE	STEP	YIELD
	U.S. BLANKS			
1	0.704 IN. .741	16	0.622 IN.	62.8%
5	0.793 IN. .830	14	0.676 IN.	64.1%
10	0.668 IN. .695	17	0.574 IN.	65.1%
25	0.905 IN. .956	13	0.778 IN.	67.4%
50	1.135 IN. 1.196	10	0.947 IN.	67.1%
1.00	1.338 IN. 1.494	8	1.199 IN.	58.9%

ABOVE FOR 12 INCH STRIP (11.9375 IN.)

Liberian Coin Programs

1970 - MAY — Letter from Tate to Higby 5/7/70

				Non Proof
.102"	1¢ (coin)	34 mm	20.75 grams.	2,000,000 Coins
.84 5"	10¢ (coin)	17 mm	2.07 grams	2,000,000 Coins

1971 - Feb 11 — Letter Tate to Higby (20,000 Proof coin blanks)

	5¢	34.0 mm	17.94 grams
		17 mm	1.71-1.79

1973 - April 2 — Ambassador Brewer to Cassidy (Proof Coin)

We made 20,000 coin blanks all denominations incl new $5.00

1¢	34 mm	17.91 grams.
10¢	17.0 mm	1.79 grams

Aug 2 1973 — We made 20,000 blanks all denominations

1¢	.088 thickness guage	
10¢	.0345	

Coin specs. (weight) has been changed since 1970 for 10¢ + 1¢ to above figures.

Currently: It would appear that the current coin (non-circ) cut blanks are as follows:

	Guage	Diameter	Wt (grams)
10¢	.0345"	17 mm	2.07
1¢	.102"	34 mm	20.75

Proof Coin, Std blank specs are as follows:

10¢	.0345"	17 mm	1.79
1¢	.088"	34 mm	17.94

Std Coin weight has been changed since 1970.

12/22/74
WHD

LIBERIAN SPECS

	1¢	5¢	10¢	25¢	50¢	$1.00
THICK BLANK	.047"	.058"	.0365"	.049"	.060"	.088"
DIA. (CUT) BLANK	.704 .704-.706	.793 .793	.668 .668	.905	1.135	1.338 1.338
DIA. UPSET BLANK	.695	.778	.652;653	.892 (S.F.)	1.125 (S.F.)	1.316 ± 1
THICK UPSET BLANK	.057	.070	.052	.060 (S.F.)	.073 (S.F.)	.118
DIA. COIN	17.9 MM 0.7047	20.0 MM 0.7874	17.0 MM .6693	23.0 MM .9055	29.0 MM 1.1417	34.0 MM 1.3386
THICK COIN	.057	.070	.0518			.118
WEIGHT	2.59g.	4.15g	31.945gr.			320.22 ± 6gr.
HARDNESS						

RED FIGURES FROM MACHINE SHOP DIE INVENTORY SHEET

Blank thickness for 10¢ + $1.00 was thicker in 1970, but coin specs (weight) was changed on these two denominations after 1970.

12/27/74

THEORETICAL RECOVERY

DENOMIN.	LIBERIAN DIE DIA. REQD.	NUMBER OF BLANKS/STROKE	STEP	YIELD
	U.S. BLANKS			
1	0.704 IN. .741	16	0.622 IN.	62.8 %
5	0.793 IN. .830	14	0.676 IN.	64.1 %
10	0.668 IN. .695	17	0.574 IN.	65.1 %
25	0.905 IN. .956	13	0.778 IN.	67.4 %
50	1.135 IN. 1.195	10	0.947 IN.	67.1 %
1.00	1.338 IN. 1.494	8	1.199 IN.	58.9 %

ABOVE FOR 12 INCH STRIP (11.9375 IN.)

Lincoln Coin Programs

1970 – MAY — Set from Tata in Italy 5/7/70

				Non Proof
.102"	1¢ (coin)	34 mm	20.75 grams.	2,000,000 Coins
.045"	10¢ (coin)	17 mm	2.67 grams	2,000,000 Coins

1971 – Feb 11 — Set from Tata in Italy (20,000 Proof coin sets)

	5¢	340 mm	17.94 grams.
		17 mm	1.74 grams.

1973 – 1 and 2 — Announce Issue of Coins (Proof Coin)

We make 20,000 coin sets. all denominations incl new $ 5¢

1¢	34 mm	17.94 grams.
10¢	17.0 mm	1.79 grams.

Coin sets — We make 20,000 sets of denominations

1¢	.088	Thickness gauge
10¢	.045	

Coin specs. (weight) has been changed since 1970 for 10¢ & $/00 to above figures.

~~Non-Proof~~ Coin sets are as follows:

	Diameter	Weight (grams)
10¢	.045"	17 mm	2.67
1¢	.102"	34 mm	20.75

Proof Coin, Tata Manufacturer

10¢	.045"	17 mm	2.67
1¢	.102"	34 mm	20.75

Set's Coin weight has been changed since 1970.

Special —

Bill Beston

DEPARTMENT OF THE TREASURY
WASHINGTON, D.C. 20220

OFFICE OF
DIRECTOR OF THE MINT

August 30, 1973

RECEIVED

SEP 6 1973

OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Mrs. Betty Higby
Superintendent
United States Mint
Denver, Colorado 80204

Dear Mrs. Higby:

Our letter of August 6 enumerated current foreign coinage programs for which you are to supply blanks or strip to San Francisco. The Liberia and Panama Proof requirements were based on the best information available at that time. We have now been provided with the actual figures, shown below, which will slightly affect the amount of material you will provide.

LIBERIA

1) 10,142 Proof Sets consisting of 95 Cu-5 Zn 1¢, 75 Cu-25 Ni 5¢, 10¢, 25¢, 50¢ and $1. You will furnish 22,000 cut blanks of each denomination.

2) 27,453 Proof $5 coins and 500 Uncirculated $5 coins 900 Ag-100 Cu. This is a new coin which is scheduled to be trial struck in mid-September. Upon successful striking, Philadelphia will furnish you with cut-blank specifications. You will then furnish San Francisco with 100 cut blanks. Upon their approval of the cut-blank specifications, you will proceed to furnish them with 56,000 cut blanks.

PANAMA

29,348 Proof 1 Balboa coins 900 Ag-100 Cu. You will furnish 58,000 cut blanks.

Approximately 160,000 fine ounces of .999 fine silver will be shipped to you from West Point as input material for the above orders.

Keep Freedom in Your Future With U.S. Savings Bonds

The strip requirement for the Honduras order and the blank requirements for the Liberia circulating and Nepal proof orders stated in our letter of August 6 are firm. The trial striking of the Honduras coin is scheduled for mid-September; we will at that time furnish you with the strip gauge specifications.

Sincerely,

George G. Ambrose
Assistant Director for Production

OPTIONAL FORM NO. 10
MAY 1962 EDITION
GSA FPMR (41 CFR) 101-11.6

UNITED STATES GOVERNMENT

Memorandum

RC

TO : Superintendents of Melting, Coining, Assay and Mechanical Divisions

DATE: August 8, 1973

FROM : Cost Accounting Branch

SUBJECT: Job Numbers - Liberia$5.00, 900 Fine Silver, 30,000 Blanks

Melting:

Dept.	Charge	Denomination
7700	7778	Ingot

Material Handling:

7800	7878-3	Strip
	7878-4	Scrap
	7878-1	Preparation of Shipment

Process Weigh:

8100	8178	Five Dollar

Rolling:

7900	7978	Five Dollar

Blanking:

8200	8278	Five Dollar

Counting:

8700	8778	Five Dollar

Assay:

3500	7778	Ingot

Mechanical:

6000	7778	Die Sets - Five Dollar

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

Card.

DEPARTMENT OF THE TREASURY
WASHINGTON, D.C. 20220

OFFICE OF
DIRECTOR OF THE MINT

August 30, 1973

RECEIVED
SEP 6 1973
OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Mrs. Betty Higby
Superintendent
United States Mint
Denver, Colorado 80204

Dear Mrs. Higby:

Our letter of August 6 enumerated current foreign coinage programs for which you are to supply blanks or strip to San Francisco. The Liberia and Panama Proof requirements were based on the best information available at that time. We have now been provided with the actual figures, shown below, which will slightly affect the amount of material you will provide.

LIBERIA

1) 10,142 Proof Sets consisting of 95 Cu-5 Zn 1¢, 75 Cu-25 Ni 5¢, 10¢, 25¢, 50¢ and $1. You will furnish 22,000 cut blanks of each denomination.

2) 27,453 Proof $5 coins and 500 Uncirculated $5 coins 900 Ag-100 Cu. This is a new coin which is scheduled to be trial struck in mid-September. Upon successful striking, Philadelphia will furnish you with cut-blank specifications. ~~You~~ Phil will then furnish San Francisco with 100 cut blanks. Upon their approval of the cut-blank specifications, you will proceed to furnish them with 56,000 cut blanks. Then melt scrap to ingots and rollingots to .150 coils. Send coils to Phil.

PANAMA

29,348 Proof 1 Balboa coins 900 Ag-100 Cu. You will furnish 58,000 cut blanks.

Approximately 160,000 fine ounces of .999 fine silver will be shipped to you from West Point as input material for the above orders.

Keep Freedom in Your Future With U.S. Savings Bonds

The strip requirement for the Honduras order and the blank requirements for the Liberia circulating and Nepal proof orders stated in our letter of August 6 are firm. The trial striking of the Honduras coin is scheduled for mid-September; we will at that time furnish you with the strip gauge specifications.

Sincerely,

George G. Ambrose
Assistant Director for Production

7- Olin Brass.

9-19-73.

	Gauge	X-Ray	# Coil	Coil Dia.	Strip size
Libra #1	-.088	.138+	6	1.338	6"
" 50¢	-.061	094+	3	1.135	6"
Nepal--1 Rupee	.058	092+1	2	1.073	6"
Libra 25¢	.049	075+	1	.905	12"
Nepal-50 Pice	.043	065+	2	.915	6"
" 25 "	.0355	057+1	1	.742	12"
Libra 10¢	.036	057	1	.668	12"

10-Coils

Libra-Proof

	B.	R
1-¢	½ hr	1
5¢	½ hr	1
10¢	½ hr	1
25¢	½	1
50¢	1	2
#1	2	3½

Nepal

25-Pice	½	1
50 "	1	1½
1-Rupee	1	1½

Boston

THE DEPARTMENT OF THE TREASURY

WASHINGTON, D.C. 20220

OFFICE OF
DIRECTOR OF THE MINT

August 6, 1973

RECEIVED

AUG 13 1973

OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Mrs. Betty Higby
Superintendent
United States Mint
Denver, Colorado 80204

Dear Mrs. Higby:

Over the past several months we have agreed to execute a number of smaller foreign coin programs in CY1973. Plans for the programs have been discussed with Mr. Lawrence from time to time relative to your furnishing coinage strip and blanks to the SFAO for their use in completing the coinage on a number of the projects.

Enclosed herewith, in summary form, is a listing of the foreign coin programs for which strip or blanks will be provided by your facility to the SFAO. We have also indicated the coinage strip (only) required for the Honduras program, and the number of blanks required on the other programs. You will also note we have included the pounds of strip believed to be required to produce the requested blanks and the alloy for each denomination of strip.

Honduras need thickness

As you have produced all the strip and blanks in the recent past for each denomination coin on each program, such information is available in your records. We therefore are not including strip gauge or cut blank diameters in our data.

Liberia need thickness diameter weight

H 5 - .50 - .25

You should have all metal on hand to produce the strip except silver. Arrangements are being made to provide you the required silver in either coin or fine bar form. It is desirable that you consolidate the strip preparation operation on the programs into a singular effort over a short time span if possible, to minimize interference with bronze strip production and to have the material completed when needed by the SFAO. Please evaluate your work situation and advise us as to the outlook for your completing all strip fabrication by October 1.

Thank you for your cooperation in this matter.

Sincerely,

Mary Brooks
Director of the Mint

Enclosure

Orig. + 2 Copies Dec.
Copy to Mailing Div. (with attach.)
Copy to Chron File (")

Keep Freedom in Your Future With U.S. Savings Bonds

Denver Fabrication Of Foreign Coinage Strip and Blanks For The STAO

Program	95/5 Bronze		75/25 Cupro-Nickel		900 F Silver	
	Strip	Blanks	Strip	Blanks	Strip	Blanks
Honduras – 4,400,000 50 Cent Circulating Coin			92,000#			
Liberia Proof Sets - 10,000 Convert Strip to Blanks						
Diameter $1.00	.088					
1.338 50¢	.061		850#	27,000		
1.135 – 25¢	.0495		420			
.905 – 10¢	.0365		200			
.668 – 5¢	.058		80			
.793 1¢	.047		190			
.705	125#	20,000				
Liberia Circulating Coins						
Diameter						
1,000,000 50¢			33,000#	1,200,000		
2,000,000 25¢			34,000	2,400,000		
1.6535 15,000 – $5					2,350#	56,000 ~~30,000~~
Convert Strip to Blanks						
Nepal – Proof Sets 8891						
1 Rupee			400#	18,000		
50 Pice			300#	18,000		
25 Pice			200#	18,000		
Convert Strip to Blanks						
						58,000
Panama – 1 Balboa, 35,000 (Convert Strip to Blanks)					8,250	~~70,000~~
Panama – Circulating + Proof	(ALL From Purchased Strip to be furnished the STAO By OFFICE FOR PRODUCTION)					
1¢ 0 — 20,000						
5¢ 5,000,000						
10¢ 10,000,000						
25¢ 800,000						
50¢ 1,000,000						

GGA 8/3/73

OPTIONAL FORM NO. 10
MAY 1962 EDITION
GSA FPMR (41 CFR) 101-11.6

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendents of Melting, Coining, Assay and Mechanical Divisions

DATE: August 8, 1973

FROM : Cost Accounting Branch

SUBJECT: Job Numbers - Liberia Proof Coin, 75 Cu. 25 Ni.-(20,000 Blanks each Denomination) - $1.00, 50¢, 25¢, 10¢, Nickels and 1 Cent (95 Cu. 5 Zn)

Melting:

Dept.	Charge	Denomination
7700	7771	Ingot (Universal)
	7772	Ingot 1 Cent

Material Handling:

7800	7871-3	Strip (Universal)
	7871-4	Scrap (Universal)
	7872-3	Strip 1 Cent
	7872-4	Scrap 1 Cent
	7873-1	Preparation of Shipment

Process Weigh:

8100	8171	$1.00, 50¢, 25¢, 10¢, 5¢
	8172	1 Cent

Rolling:

7900	7972	Cents
	7973	Nickels
	7974	Dimes
	7975	Quarters
	7976	Halves
	7977	Dollars

Blanking:

8200	8272	Cents
	8273	Nickels
	8274	Dimes
	8275	Quarters
	8276	Halves
	8277	Dollars

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

3-29-72

LIBERN CENT.

LAST PASS

X-RAY - 074 1/2 = .047

EDGE = 046 DIA - 705

wt = 40 grs

Liberian - Proof

1 - Cent

.047

40 grains

Liberian Proof 1¢

Hollinger Corp.
pH 8.5

Mr. J. F. Carville

April 2, 1973

George G. Ambrose Initialed

RECEIVED
APR 3 - 1973
OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Cost Estimate - 1973 Liberia Proof Coin Sets and New 1973 Liberia Proof Five-Dollar Coin.

This memorandum supercedes my memorandum dated March 30, subject as above, in the interest of clarification.

Please prepare cost estimates as follows on subject proof coin programs.

LIBERIA INDIVIDUAL 5-DOLLAR PROOF COIN

1. Prepare a cost estimate for the manufacture of 3,000 and for 5,000 individual new 5-dollar proof coin.
2. Include all engraving costs, trial strike costs, and experimental die and collar costs.
3. Amount and estimated cost of silver and copper required for each lot is to be determined.
4. Specifications:

Diameter	42mm
Weight	550 grains (35.64 grams)
Alloy	.900 fine silver
Edge	reeded

LIBERIA PROOF COIN SETS

1. Prepare a cost estimate for the manufacture of 5,000 sets and for 10,000 sets consisting of 7 coins each as follows. No guarantee on "frosted" sets.

Denomination	Alloy	Weight (Grams)	Diameter (MM)
5 Dollar (reeded	90 Ag - 10 Cu	35.64	42.0 1.65357
1 Dollar edge)	75 Cu - 25 Ni	17.94	34.0 1.33858
50 Cent	75 Cu - 25 Ni	8.97	29.0 1.14173
25 Cent	75 Cu - 25 Ni	4.48	23.0 .9055
10 Cent	75 Cu - 25 Ni	1.79	17.0 .66929
5 Cent	75 Cu - 25 Ni	4.15	20.0 .78740
1 Cent	95 Cu - 5 Zn	2.59	17.9 .704723

3/5/73.
1 - Copy To [illegible]
E.J.

2. Amount and estimated cost of metal required per each lot of coins (5,000 or 10,000 sets).
3. Include cost of changing dates on the 1-cent through 1-dollar dies.
4. Cost of trial strike on coins to be included.

GENERAL

1. All our blanks will be provided by the Denver Mint from strip prepared by that facility. Assume the number of blanks to be provided by Denver to be:

$5-Dollar Individual Coin	3,000 Coins 4,000 blanks	5,000 Coins 6,500 blanks
Proof Sets	5,000 Sets	10,000 Sets
$5-dollar coin	6,500 blanks	13,000 blanks
$1-dollar	7,000	14,000
50-cents	7,000	14,000
25-cent	7,000	14,000
10-cent	7,000	14,000
5-cent	7,000	14,000
1-cent	6,500	13,000

2. Insure that adequate cost is provided for frequent tooling setup and tear-down and for the fabrication of a punch and dieseta set as well as the fabrication of upset groove and segment.
3. Include transportation costs of virgin metal to Denver Mint and the cost of transporting blanks from Denver to the SFAO.
4. All 5-dollar proof coins, individual or for proof sets, will be wrapped in tissue. All proof set coins other than the 5-dollar coin will be packaged in a six-coin "mylar" heat sealed package as in 1972.
5. Coins will be produced at the SFAO, between the period of November 1 and December 31, 1973.
6. FOB loading dock SFAO.

cc: Mrs. Brooks
R.G. Cahoon
A.J. Goldman
Supt., Denver Mint
Officer in Charge, SFAO
G.G. Ambrose

GGA:ifb

RECEIVED
APR 18 1973
OFFICE OF THE SUPERINTENDENT
U. S. MINT AT DENVER

April 13, 1973

Mr. Nicholas C. Theodore
Superintendent
United States Mint
Independence Hall
Philadelphia, Pa. 19106

Dear Mr. Theodore:

The Government of Liberia has decided to add a 5 Dollar proof coin to their 1973 Proof Set. These coins will be manufactured at the San Francisco Assay Office from blanks to be supplied by the Denver Mint. The coin has the following specification:

Alloy	Weight	Diameter	Edge
900 Ag-100 Cu	550 Grains	42 MM	Reeded

The designs for the obverse and reverse dies were transmitted under cover of our letter of March 29, 1973. The coins will be dated 1973.

It is requested that each office perform the following actions relative to this program:

Philadelphia Mint

1. Proceed through the manufacture of trial dies.

2. Fabricate collars for trial strike.

3. Empirically develop specifications for the 5 Dollar blank, including thickness, diameter, and upset edge. Prepare a suitable range of blank configurations in several sizes at standard weight. It is understood that you have .900 fine silver material available which can be rolled to gauge and blanked out to provide material for the trial striking.

4. Liberia has requested that we furnish five (5) specimens of proof quality, hence, it will be necessary that the blanks to be used be burnished.

5. Furnish the San Francisco Assay Office with six (6) each cut and upset blanks of the most suitable dimension, to be determined through trial striking; two (2) trial strikes; one (1) pair dies; and one (1) collar; drawings showing the design details of the segment and dies used to upset the blanks.

6. Advise this office when work has progressed to the point where a trial strike can be scheduled.

San Francisco Assay Office

1. Retain in custody the trial strikes, experimental dies, collar, and blanks from Philadelphia until you are advised by this office of Liberia's approval. At that time set up and confirm that the blank configuration developed and determined to be most suitable at the time of the trial striking is acceptable.

2. Proceed with manufacture of upsetting segments and dies.

3. Delay ordering of blanks from Denver and dies and collars from Philadelphia until Liberia advises us of their actual Proof Set and 5 Dollar requirements. These items are to be ordered through this office.

Denver Mint

1. Manufacture cut blanks, in requested number, per San Francisco specification, and ship.

By copy of this letter, the Superintendent of the Denver Mint and the Officer in Charge, San Francisco Assay Office, is requested to complete the appropriate action requested above.

Sincerely,

(Signed) F. H. MacDonald

F. H. MacDonald
Acting Director of the Mint

cc: Mrs. Brooks
S.F.A.O.
✓Denver Mint
S. F. Carullo
R. C. Calhoon
A. J. Goldman

VJC:dm CCA F.H.MacD

3-29-72

LIBERIA - CENT - LAST PASS

X-RAY - 074 ± 1/2 = .047-

EDGE = .046- DIA = .705 WT 40 grs

OPTIONAL FORM NO. 10
MAY 1962 EDITION
GSA FPMR (41 CFR) 101-11.6

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendent's of Melting, Coining, Cash & Deposits, Assay and Mechanical Div.

DATE: February 10, 1972

FROM : Cost Accounting Branch

SUBJECT: Job Numbers for Liberian 1 cent and 5 cent coins

Melting

Dept.	Charge	Denomination
7700	7766	1¢ Ingot
7700	7767	5¢ Ingot

Process-Weighing

8100	8166	1 Cent
8100	8167	5 Cent

Rolling (Includes Slab Annealing)

7900	7966	1 Cent
7900	7967	5 Cent

Blanking

8200	8266	1 Cent
8200	8267	5 Cent

Annealing

8300	8366	1 Cent
	8367	5 Cent

Upsetting

8500	8566	1 Cent
8500	8567	5 Cent

Selecting

8800	8866	1 Cent
8800	8867	5 Cent

Stamping

8600	8666	1 Cent
	8667	5 Cent

8010-106

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

OPTIONAL FORM NO. 10
MAY 1962 EDITION
GSA FPMR (41 CFR) 101-11.6

UNITED STATES GOVERNMENT

Memorandum

R+C

TO : Superintendents of Melting, Coining, Assay and Mechanical Division

DATE: March 3, 1971

FROM : Cost Accounting Branch

Completed 8-19-71

SUBJECT: Job Numbers for Liberian 1 Cent, 5 Cent, 10 Cent, 25 Cent, 50 Cent and 1 Dollar Blanks

	Dept.	Charge	Denomination
Melting:	7700	7789	1 Cent Ingot
	7700	7790	Universal Ingot
Process Weighing:	8100	8189	1 Cent
		8190	5 Cent
		8191	10 Cent
		8192	25 Cent
		8193	50 Cent
		8194	1 Dollar
Rolling: (Includes 7900 Slab Annealing)		7989	1 Cent 7966 4-29-72
		7990	5 Cent
		7991	10 Cent
		7992	25 Cent
		7993	50 Cent
		7994	1 Dollar
Blanking:	8200	8289	1 Cent 8266 4-29-72
		8290	5 Cent
		8291	10 Cent
		8292	25 Cent
		8293	50 Cent
		8294	1 Dollar
Counting:	8700	8789	1 Cent
		8790	5 Cent
		8791	10 Cent
		8792	25 Cent
		8793	50 Cent
		8794	1 Dollar
Stores Items:		8789	1¢ Bags
		8790	5¢ Bags
		8791	10¢ Bags
		8792	25¢ Bags
		8793	50¢ Bags
		8794	1 Dollar Bags

5010-106

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

MEMORANDUM - CONTINUED

SUBJECT: Job Numbers for Liberian 1 Cent, 5 Cent, 10 Cent, 25 Cent, 50 Cent and 1 Dollar Blanks

Assay:	Dept.	Charge	Denomination
	3500	7789	1¢ Ingot
		7790	Universal Ingot
Mechanical Division:	6000	8289	1 Cent Die Sets and Thimbles, etc.
		8290	5 Cent Die Sets and Thimbles, etc.
		8291	10 Cent Die Sets and Thimbles, etc.
		8292	25 Cent Die Sets and Thimbles, etc.
		8293	50 Cent Die Sets and Thimbles, etc.
		8294	1 Dollar Die Sets and Thimbles, etc.

OPTIONAL FORM NO. 10
MAY 1962 EDITION
GSA FPMR (41 CFR) 101-11.6

UNITED STATES GOVERNMENT

Memorandum

Rolling + Cutting

TO : Superintendents, M&R, Coining, Assay, and Mechanical Divisions

DATE: November 5, 1968

FROM : Cost Accounting Section

SUBJECT: Liberian Proof Coin Sets--Ingots and processing to blanks-Job numbers

DEPT

7700 M&R Make-up & Melting
Charge
7730- Bronze Ingot

Charge
7731- Cupro-Nickel Ingot

DEPT

8100 Process Weighing
1 8130- 1Cent
2 8131- 5 Cent
1 8132- 10 Cent
2 8133- 25 Cent
3 8134- 50 Cent
6 8140- One Dollar

No. of Ingots =

DEPT

8200 Rolling & Blanking
8230-R- 1 Cent rolling, cutting, etc...
8230-B- 1 Cent blanking
8231-R- 5Cent rolling, slab annealing, etc...
8231-B- 5 Cent blanking
8232-R- 10 Cent rolling, slab annealing, etc...
8232-B- 10 Cent Blanking
8233-R- 25 Cent rolling , slab annealing, etc...
8233-B- 25 Cent blanking
8234-R- 50 Cent rolling, slab annealing, etc...
8234-B- 50 Cent blanking
8240-B- One Dollar banking
8240-R- One Dollar rolling, slab annealing, etc...

One man:
8230R - 2 hrs
8230B ½ hr.
8231R ½ hrs
8231B 1 hr
8232-R 3½
8232-B- 1½
8233-R - 2
8233-B- 1
8234-R - 2½ hrs.
8234-B- 1 hr
8240R = 3
8240-B - 1½

5010-106

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

(MEMORANDUM Continued-)

Preparation of Shipment

DEPT

8700 Counting-blanks-bags
Bagging, weighing and placing bags in locked bins
8730- 1 Cent
8731- 5 Cent
8732- 10 Cent
8733- 25 Cent
8734- 50 Cent
8740- One Dollar

DEPT

3500 Assay
Charge
7730- Bronze

7731- Cupro-Nickel

DEPT

6000 Mechanical
Charge
8230- 1 Cent Die Sets
8231- 5 Cent Die Sets
8232- 10 Cent Die Sets
8233- 25 Cent Die Sets
8234- 50 Cent Die Sets
8240- One Dollar Die Sets

8230-1- 1 Cent Thimbles
8231-1- 5 Cent Thimbles
8232-1- 10 Cent Thimbles
8233-1- 25 Cent Thimbles
8234-1- 50 Cent Thimbles
8240-1- One Dollar Thimbles

OPTIONAL FORM NO. 10
REVISED EDITION
GSA FPMR (41 CFR) 101-11.6

UNITED STATES GOVERNMENT

Memorandum

RR. V
J. Wes

TO : Superintendents of Melting, Coining and Mechanical Divisions

DATE: June 11, 1971

FROM : Cost Accountant

SUBJECT: 3,000 Pieces of German Silver Cut Blanks

Melting	Dept.	Charge
	7700	7750
Process-Weighing	8100	8150
Rolling(Includes Slab Annealing)	7900	7950
Blanking	8200	8250
B&M	6000	8250

OPTIONAL FORM NO. 10
MAY 1962 EDITION
GSA FPMR (41 CFR) 101-11.6

Rolling & Cutting

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendents of Melting, Coining, Assay, C & D, and Mechanical Divisions.

DATE: May 12, 1970

FROM : Cost Accounting

SUBJECT: Job Numbers for Liberia 2,000,000 pieces Dollar Denomination and 2,500,000 pieces Ten Cent Denomination

Melting

Dept.	Charge	
7700	7784	Ingot

Process Weigh

Dept.	Charge	
8100	8184	

Rolling

Dept.	Charge	
7900	7984	10 Cent - Rolling, Slab Annealing, etc.
7900	7985	Dollar - Rolling, Slab Annealing, etc.

Blanking

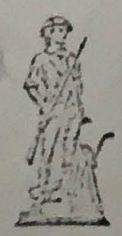
Dept.	Charge	
8200	8284	10 Cent
8200	8285	Dollar

Annealing and Cleaning

Dept.	Charge	
8300	8384	10 Cent
8300	8385	Dollar

Selecting

Dept.	Charge	
8800	8884	10 Cent
8800	8885	Dollar



5010-104

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

Memorandum - Continued

Subject: Job Numbers for Liberia 2,000,000 pieces Dollar Denomination and 2,500,000 pieces Ten Cent Denomination

Automatic Weigh

Dept.	Charge	
8400	8485	Dollar

Stamping

Dept.	Charge	
8600	8684	10 Cent
8600	8685	Dollar

Counting

Dept.	Charge	
8700	8784	10 Cent - Bagging, Weighing
	8785	Dollar - Bagging, Weighing
Stores Items	8784	10 Cent Bags
" "	8785	Dollar Bags

Cash and Deposits

Dept.	Charge	
Stores Items 1300	1386	10 Cent Boxes
Stores Items	1387	Dollar Boxes

Preparation of Shipment

Dept.	Charge	
1300	1388	10 Cent Boxing Bags and Banding Boxes
	1389	Dollar - Boxing Bags and Banding Boxes

Assay

Dept.	Charge	
3500	7784	Ingot

Mechanical

Dept.	Charge	
6000	8284	10 Cent - Changing & Sharpening Die Sets
	8285	Dollar - Changing & Sharpening Die Sets
	8584	10 Cent - Segments, etc.
	8585	Dollar - Segments, etc.

OPTIONAL FORM NO. 10
MAY 1962 EDITION
GSA FPMR (41 CFR) 101-11.6

UNITED STATES GOVERNMENT

Memorandum

TO : **Superintendents of Melting, Coining, Assay and Mechanical Divisions**

DATE: **November 10, 1970**

FROM : **Cost Accounting Branch**

SUBJECT: **Job Numbers for Nepal Blanks in Rupee, 50 Pice and 25 Pice Denominations**

Operations	Dept.	Charge	Denomination
Melting:	7700	7766	Ingot
Process Weighing:	8100	8166	25 Pice
		8167	50 Pice
		8168	Rupee
Rolling: (Includes Slab Annealing)	7900	7966	25 Pice – ½ hr
		7967	50 Pice ½ hr
		7968	Rupee ½ hr
Blanking:	8200	8266	25 Pice – ½ hr
		8267	50 Pice
		8268	Rupee
Counting:	8700	8766	25 Pice
		8767	50 Pice
		8768	Rupee
Assay:	3500	7766	Ingot
Mechanical:			
Changing & Sharpening Punch Die Sets	6000	8266	25 Pice
		8267	50 Pice
		8268	Rupee

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

TREASURY DEPARTMENT
WASHINGTON, D.C. 20220

OFFICE OF
DIRECTOR OF THE MINT

October 28, 1968

RECEIVED

NOV 4 - 1968

OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Mrs. Marian N. Rossmiller
Superintendent
United States Mint
Denver, Colorado 80204

Dear Mrs. Rossmiller:

You are requested to produce 20,000 cut blanks of each of the following denominations for use in manufacturing Liberian Proof Coin Sets. Specifications of the finished coins are as follows:

Denomination	Alloy	Diameter in Millimeters		Thickness in Millimeters		Wgt. Grams	
			cut blank				
1 1 cent	95Cu/ 5Zn	17.9	.704	1.40		2.59196	40 grains
1 5 cents	75Cu/25Ni	20.0	.793	1.73		4.14713	64 "
1 10 cents	75Cu/25Ni	17.0	.668	1.17	.037	1.79426	27.69
2 25 cents	75Cu/25Ni	23.0	.905	1.50	.050	4.48564	69.224
2 50 cents	75Cu/25Ni	29.0	1.135	1.90	.061	8.97128	138.448
3 1 dollar	75Cu/25Ni	34.0	1.338	2.74	.088	17.94256	276.896

After you produce the blanks they should be shipped to the San Francisco Assay Office in bags placed in locked bins.

Thank you for your assistance in this matter.

Sincerely,

Eva Adams

Eva Adams
Director of the Mint

(Copies: Acting M+R Chief M.)

Keep Freedom in Your Future With U.S. Savings Bonds

Boston

Read & Initial
E.F.B. .....
....
....
Then File

TREASURY DEPARTMENT
WASHINGTON, D.C. 20220

OFFICE OF
DIRECTOR OF THE MINT

November 16, 1967

RECEIVED
NOV 20 1967
OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Mrs. Marian N. Rossmiller
Superintendent
United States Mint
Denver, Colorado 80204

Dear Mrs. Rossmiller:

In addition to our letter of November 9, 1967 and confirming our phone conversation of November 13, 1967, listed below are the diameters and gauges of the cut blanks for the proposed proof coin order for the Government of Liberia.

Denomination	Cut Blank Diameter	Cut Blank Gauge
$ .01 Bronze	.704	* N/A
.05 nickel	.793	* N/A
.10 ~~A C silver~~	75 % .668	.037
.25 ~~A C "~~	25 % .905	.050
.50 ~~A C "~~	1.135	.061
1.00 ~~A C "~~	1.338	.088

* Not Available

Sincerely,

Eva Adams

Eva Adams
Director of the Mint

H. Lawrence
copy - Ambrose

Keep Freedom in Your Future With U.S. Savings Bonds

TREASURY DEPARTMENT
WASHINGTON, D.C. 20220

2267

OFFICE OF
DIRECTOR OF THE MINT

November 16, 1967

RECEIVED
NOV 20 1967
OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Mrs. Marian N. Rossmiller
Superintendent
United States Mint
Denver, Colorado 80204

Dear Mrs. Rossmiller:

In addition to our letter of November 9, 1967 and confirming our phone conversation of November 13, 1967, listed below are the diameters and gauges of the cut blanks for the proposed proof coin order for the Government of Liberia.

Denomination	Cut Blank Diameter	Cut Blank Gauge		
$ .01 95% Cu 5% Zn	.704 .046", .047	* N/A	2.592 gms.	
.05	.793 .058 .058	* N/A	4.147 "	
.10 75% Cu	.667 .668	.037	1.794 "	27.69
.25 25% Ni	.905	.050	4.486 "	69.22
.50	1.135	.061	8.971	138.45
1.00	1.338	.088	17.943 "	276.90

Grams

* Not Available

Sincerely,

Eva Adams
Director of the Mint

H. Lawrence
copy. Ambrose

Keep Freedom in Your Future With U.S. Savings Bonds

Form 8903
Treasury Department
U.S. Mint Service

FOREIGN COINAGE

ADMINISTRATIVELY CONFIDENTIAL

Government Liberia — No. Pieces 2,000,000

Date order received May 20, 1970	Was master die furnished No
Mint where coined Denver, Colorado	Was master die returned No
Denomination Dollars	Number melts made 428
Date coinage started June 1, 1970	No, melts delivered to Coiner 428
Date coinage completed July 10, 1970	Ounces per melt 5800
Cost per M	No. ingots per melt One
Alloy Cupro - Nickel	Weight per ingot 400 lbs.
Weight per coin 320.22 ± 6 Grains	Size of ingot 60"X12 1/8"X1 3/4"
Weight tolerance ± 6 Grains	Assay passing tol. on ingot
Fineness Tol.	Diameter of cut blank 1.338
Diameter 1.3385 Tol.	Thickness of cut blank .102
Thickness .118 Tol.	Diameter of upset blank 1.316 ± .001
Reeded edge Yes	Edge thickness upset blank .118
Plain edge No	Pieces cut across strip 2
Lettered edge No	Pieces cut at one stroke 4
	Hardness Test Max. 25
Wastage allowed per M	Annealing temperature 1600°
Turn - standard or medal Standard	% rejects, automatic scales No
Year (dated) 1970	% rejects if reviewed 17,076 OZ.
Mint mark No	% good coins from ingots 60 %
Was sample coin submitted Yes	No. pieces per bag 1,000
Was sample strike approved Yes	~~Weight x No. x Pieces~~ 1,489,830
Settlement June 12 thru July 5, 1970	Balance of Blanks 124,300
	Date shipped

Remarks:
Received 4 new collars to start job - did not draw them and broke all 4 without getting 100,000 strikes. Received 6 more new ones - had them drawn. Cracked one and finished with 5 new collars.

Form 8903
Treasury Department
U.S. Mint Service

FOREIGN COINAGE

ADMINISTRATIVELY CONFIDENTIAL

Government Liberia

No. Pieces 10,000,000

Date order received February 22, 1972

Mint where coined Denver

Denomination One Cent

Date coinage started April 3, 1972

Date coinage completed April 25, 1972

Cost per M

Alloy 95 cu - 52 n

Weight per coin 2.59 Grams

Weight tolerance

Fineness Tol.

17.9 MM

Diameter .7047 Tol.

Thickness .057 Tol.

Reeded edge

Plain edge Yes

Lettered edge

Wastage allowed per M

Turn - standard or medal Standard

Year (dated) 1972

Mint mark

Was sample coin submitted Yes

Was sample strike approved

Was master die furnished No

Was master die returned

Number molts made 247 Ingots

No. molts delivered to Coiner

Ounces per molt

No. ingots per molt

Weight per ingot 400 lbs. -6,000 oz.

Size of ingot 60"x12 1/2x1 3/4"

Assay passing tol. on ingot

Diameter of cut blank .704

Thickness of cut blank .047

Diameter of upset blank .695

Edge thickness upset blank .057

Pieces cut across strip 8 - 9

Pieces cut at one stroke 17

Annealing temperature 1300°

% rejects, automatic scales

% rejects if reviewed

% good coins from ingots 60%

No. pieces per bag

Weight tol., M pieces 5,000

Date shipped

Remarks: Used dime equipment for stamping and U.S. Cent upsetting.
Used conventional presses

DIE AVERAGE:
Obverse - 850,000
Reverse - 850,000

Notes on Liberian Currency